



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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RB6798927
Job Sheet 197433



Part No: RB6798927

Job Qty: 3 pcs

Part Name: Compressor Impeller Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/8/19

Job Tracking No:

Due Date: 7/31/19

Created By: Marie Lajeunesse

Type: SOLD

Description: ORDER 14774-16098-16107

Note: DWG RB6798927 Rev.C IPP Rev. A 18.05.29 new issue DP Verify DD/IPP Rev. B 19.07.05 Rev C DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	3 pcs	7/31/19		0.00	0.21	Small Fab - 1		MLC
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	3 pcs	7/31/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
130	Packaging 3-1 - Stock - B4B	3 pcs	7/31/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		



Container No: S197811



Part: RB6798927

Job No: 197433

Serial No/Batch: S197811

Revision: C

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/15/19

DAS
40
9-99

15 2019

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				Packaging 3 - 5 - B4B					
				Packaging 3 - 6 - B4B					
				Packaging 3 - 7 - B4B					
				Packaging 3 - 8 - B4B					
				Packaging 3 - 9 - B4B					
				Packaging 3 - 10 - B4B					
				Packaging 3 - 11 - B4B					
				Packaging 3 - 12 - B4B					
				Packaging 3 - 13 - B4B					
				Packaging 3 - 14 - B4B					
				Packaging 3 - 15 - B4B					
				Packaging 3 - 16 - B4B					
				Packaging 3 - 17 - B4B					
				Packaging 3 - 18 - B4B					
				Packaging 3 - 19 - B4B					
				Packaging 3 - 20 - B4B					
				Packaging 3 - 21 - B4B					
				Packaging 3 - 22 - B4B					
				Packaging 3 - 23 - B4B					
				Packaging 3 - 24 - B4B					
				Packaging 3 - 25 - B4B					
				Packaging 3 - 26 - B4B					
				Packaging 3 - 27 - B4B					
				Packaging 3 - 28 - B4B					
				Packaging 3 - 29 - B4B					
				Packaging 3 - 30 - B4B					
				Packaging 3 - 31 - B4B					
				Packaging 3 - 32 - B4B					
				Packaging 3 - 33 - B4B					
				Packaging 3 - 34 - B4B					
				Packaging 3 - 35 - B4B					
				Packaging 3 - 36 - B4B					
				140 QC 21 - FG	3 pcs	7/31/19	0.00 0.00	QC 21 - FG - 21	
								QC 21 - FG - 70	JUL 16 2019
								QC 21 - SA - 53	

Part Op 100 - (Small Fab) Assemble as per drawing see note 8 and 9.

Descriptions: 110 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location:) Identify and Stock The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
94846A029	Hex Jam Nut	3 Ea (1 ea)	100-Small Fab - 1	5079639
98381A314	Dowel	3 Ea (1 ea)	100-Small Fab - 1	5079640
RB6798927-1	Jaw Weldment	3 pcs (1 ea)	100-Small Fab - 1	5186996
RB6798927-2	Crimper Weldment	3 pcs (1 ea)	100-Small Fab - 1	5187119
RB6798927-4	Cone Point Set Screw	3 pcs (1 ea)	100-Small Fab - 1	5090302

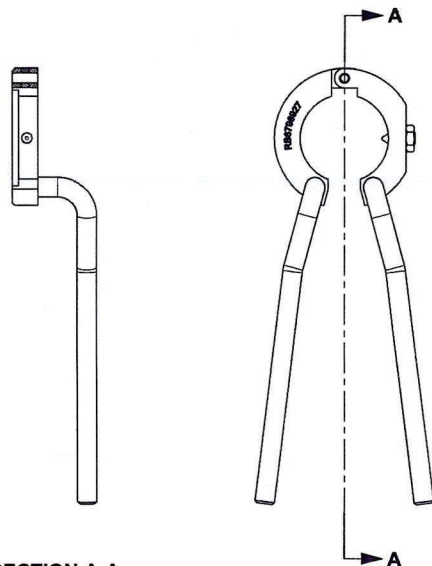
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	94846A029	3	97	0
	98381A314	3	23	0
	RB6798927-1	3	4	0
	RB6798927-2	3	4	0
	RB6798927-4	3	4	0

Part Specifications
Specifications could not be found.

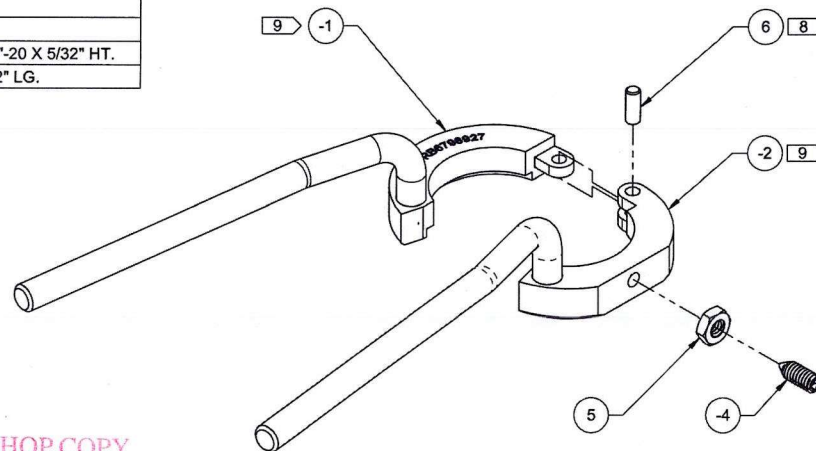
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ITEM #	QTY	PART #	PART TITLE
-1	1	RB6798927-1	JAW WELDMENT
-2	1	RB6798927-2	CRIMPER WELDMENT
-4	1	RB6798927-4	CONE POINT SET SCREW
5	1	McMaster#93839A029 OR EQUIV.	GRADE 8 YELLOW ZINC PLATED STEEL THIN HEX NUT 1/4"-20 X 5/32" HT.
6	1	McMaster#98381A314 OR EQUIV.	BLACK OXIDE STEEL DOWEL PIN 3/16" DIA. X 1/2" LG.



SECTION A-A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 197433 M15
19-07-08



RB6798927 CRIMPER-LOCK NUT COMPRESSOR IMPELLER ASSY AND TURBINE POWER SHAFT

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
THEN PRESS FIT ITEM 6 WITH ITEM -1, AND REMOVE EXCESS
- 9) ITEM -1 AND ITEM -2 MUST ROTATE FREELY
- 10) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

SEE PREVIOUS REVISION FOR MORE INFORMATION UPDATED DRAWING TEMPLATE ITEM 5 WAS ITEM -5 MCMASTER-CARR #94846A029 IS McMaster#93839A029 -1 ITEM NAME WAS JAW IS JAW WELDMENT. DIM WAS 0.75 IS 0.75 REF. REMOVED ENGRAVING NOTE -1A ITEM NAME WAS JAW PART IS JAW. DIM WAS ϕ .1874-.1867 IS ϕ .1875-.1867. DIM WAS ϕ .385+.020/-0.000 IS ϕ .386. DIM WAS .170+.005 IS 0.180-0.175. REMOVED .56 DIM. ADDED R0.008 MAX DIM. ADDED ENGRAVING NOTE -1B ITEM NAME WAS JAW PART IS JAW HANDLE. REMOVED ϕ .375+.005/-0.020 AND .060 DIMS. ADDED R0.38 DIM AND FLAT PATTERN -2 ITEM NAME WAS CRIMPER JAW IS CRIMPER WELDMENT -2A ITEM NAME WAS JAW PART IS CRIMPER. DIM WAS ϕ .385+.020/-0.000 IS ϕ .386. DIM WAS ϕ .1902-.1890 IS ϕ .1890. REMOVED .56 DIM. ADDED R0.008 MAX DIM -2B ITEM NAME WAS JAW PART IS CRIMPER HANDLE. REMOVED ϕ .375+.005/-0.020 AND .060 DIMS. ADDED R0.38 DIM AND FLAT PATTERN		19-752	KPT
REV.	DESCRIPTION	ECN #	BY
DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT	REV C	
CHECKED	MBB	SHEET 1 OF 8	
MFG. APPR.	FK	SCALE	
APPROVED	Wp	NTS	
DATE	2019-07-04	TITLE CRIMPER-LOCK NUT COMPRESSOR IMPELLER ASSY AND TURBINE POWER SHAFT COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐									
Date :		Sequence #:		QTY Affected :		MRB (QSI042)					
Description Work Order Deviation				Disposition							
				<i>Dot mark + black paint</i>							
								Completed By			
								Lead hand / Supervisor			
QC / QA Coordinator											
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		Other/Details:									